

Work Order ID 163477

Tuesday, June 27, 2017 1:17:32 PM

163477

Page 1

Item ID: D4148-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Crosstube Lug Assembly
Start Date: 6/27/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/29/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUN 28 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	E ☒								
100		0.00							
100									
Small Fab	Memo	0.52							
Small Fab	1- Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.04							
Quality Control									
120	Identify as per dwg & Stock Location <u>5039</u>	0.00							
120									
Packaging	Memo	0.02							
Packaging									

DAS
36
9-89

DAS
38
9-89
JUL 14 2017

DAS
39
9-89

JUL 19 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

JUL 19 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Page 1

Work Order ID: 163477

163477

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 6/27/2017

Required Date: 6/29/2017

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

10.10.29 as per revC DD verf:EC

AS PER DWG REV.D DD VERF:EC

IPP Rev:C

IPP REV:D 11.03.02

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	632.0000	4	4			

MS21043-3

Nut

**

DAS
6
9-89

JUL 12 2017

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

119

m136182

119

GA

84

m136182

84

OVER007

300

m137587

300

ST302

49

m137459

49

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																										
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D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 6/27/2017

Required Date: 6/29/2017

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

100

Each

750.0000

1

6

MS21043-4

Nut

**

DAS

JUL 12 2017

6
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

99

m132803

5

m137371

94

OVER007

300

m137886

300

ST302

311

m137361

111

m137371

200

6

D2690-6

Manufactured

No

100

Each

41.0000

1

2

D2690-6

Lanyard

**

DAS

JUL 12 2017

6
9-89

Location

Loc Qty

Loc Code

ST009

41

159568

23

162919

18

2

D3910-1

Manufactured

No

100

Each

14.0000

1

2

D3910-1

Crosstube Lug

**

DAS

JUL 12 2017

6
9-89

Location

Loc Qty

Loc Code

ST525

14

159145

14

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																									

Picklist Print

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Page 3

Work Order ID: 163477

163477

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 6/27/2017

Required Date: 6/29/2017

Start Qty: 2.00

Required Qty: 2.00

D4091-1 Manufactured No

100 Each 30.0000 1 2

D4091-1

Mounting Lug

**

DAS
6
9-89

JUL 12 2017

Location

Loc Qty

Loc Code

ST525

30

161296

30

D4148-1 Manufactured No

100 Each 11.0000 2 4

D4148-1

Crosstube Lug Plate, Fwd

**

DAS
6
9-89

JUL 12 2017

Location

Loc Qty

Loc Code

ST085

11

161842

11

D4148-3 Manufactured No

100 Each 19.0000 1 2

D4148-3

Stud Receiver, Lower

**

DAS
6
9-89

JUL 12 2017

Location

Loc Qty

Loc Code

ST086

19

157016

7

162832

12

D4148-5 Manufactured No

100 Each 15.0000 1 2

D4148-5

Eyebolt Stud

**

DAS
6
9-89

JUL 12 2017

Location

Loc Qty

Loc Code

ST086

15

158933

15

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Page 4

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163477

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 6/27/2017

Required Date: 6/29/2017

Start Qty: 2.00

Required Qty: 2.00

AN3C12A Purchased No

100 Each 91.0000 2 4

AN3C12A

Bolt

**

JUL 12 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

GA 28

M128727 7

M133990 21

ST349 63

M137507 63

AN4C13A Purchased No

100 Each 60.0000 3 6

AN4C13A

BOLT

**

DAS
6
9-89

JUL 12 2017

Location

Loc Qty

Loc Code

GA 26

m137699 26

ST344 34

m137321 2

m137495 32

MS17984-C413 Purchased No

100 Each 28.0000 1 2

MS17984-C413

Quick Release Pin

**

DAS
6
9-89

JUL 12 2017

Location

Loc Qty

Loc Code

ST315 28

m137478 25

m137587 3

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
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Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 6/27/2017

Required Date: 6/29/2017

Start Qty: 2.00

Required Qty: 2.00

MS20615-4M18

Purchased

No

100

Each

93.0000

8

16

MS20615-4M18

Rivet

**

JUL 12 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

40

m134762

40

ST306

53

m137361

53

NAS1149C0332R

Purchased

No

100

Each

4,910.000

4

8

NAS1149C0332R

WASHER

**

DAS
6
9-89

JUL 12 2017

Location

Loc Qty

Loc Code

FP001

1470

m137597

1470

GA

508

m133284

22

m136444

486

ST260a

2000

m135408

0

m136741

0

m137851

2000

ST266

932

m137381

932

NAS1149C0432R

Purchased

No

100

Each

1,235.000

6

12

NAS1149C0432R

WASHER

**

DAS
6
9-89

JUL 12 2017

Location

Loc Qty

Loc Code

GA

341

m134676

341

ST266

894

m137459

894

Tuesday, June 27, 2017 1:17:35 PM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																